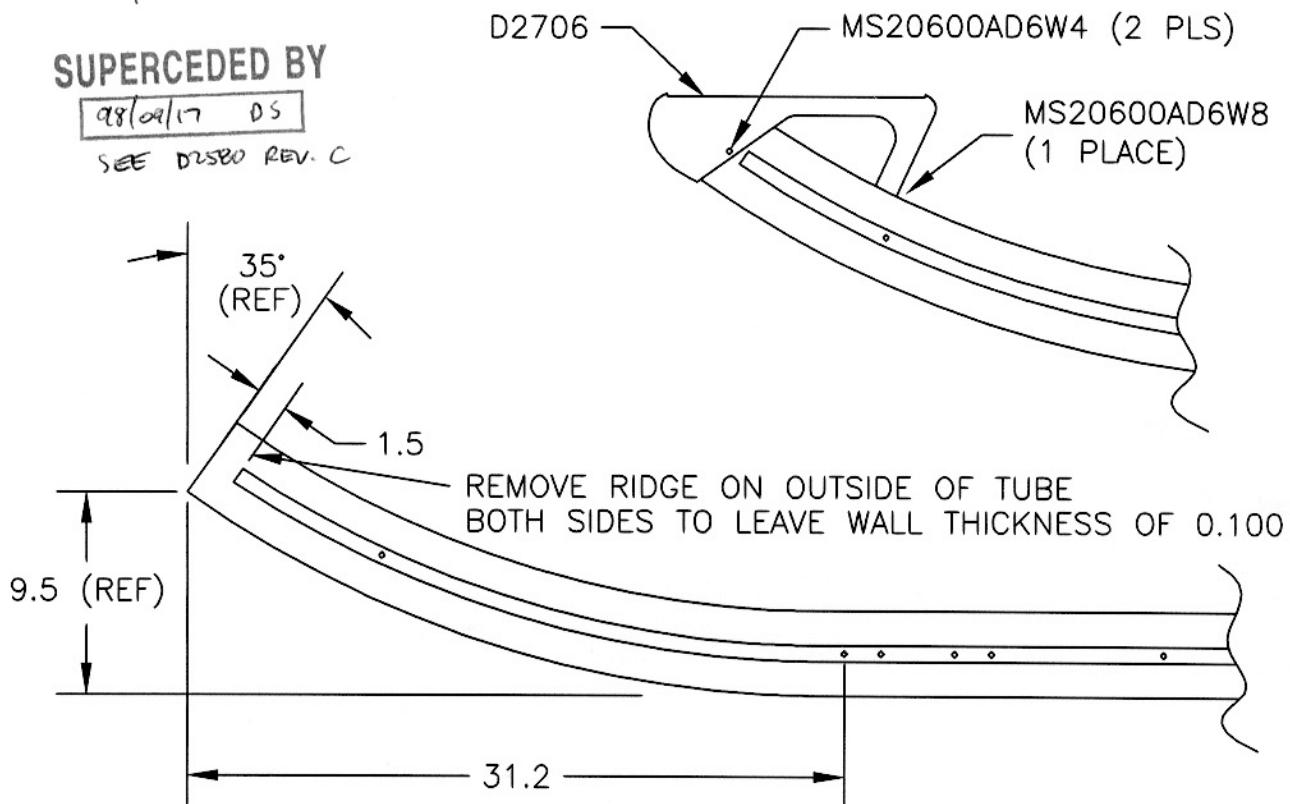


**DART**

|                      |                       |  |
|----------------------|-----------------------|--|
| DESIGN<br><i>DM</i>  | DRAWN BY<br><i>RE</i> | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED<br><i>MM</i> | APPROVED<br><i>JS</i> | DRAWING NO.<br>DEO 9087                                      |
| DATE<br>97.10.15     |                       | TITLE<br>205 SKIDTUBE STEP CHANGE                            |
| A                    | 97.10.15              | SCALE<br>NTS<br>NEW ISSUE                                    |

# DART ENGINEERING ORDER

TO AMEND DART DRAWINGS D2580 REV B

**RELEASED**  
97/10/23 DS**SUPERCEDED BY**98/02/17 DS  
SEE D2580 REV. C

1. CUT TUBE TO DIMENSIONS SHOWN AND DE-BURR
2. REMOVE RIDGE ON OUTSIDE OF TUBE
3. LOCATE D2706 STEP
4. TRANSFER DRILL  $\varnothing 0.191$  TO SKIDTUBE (3 PLACES) AND REMOVE SWARF
5. INSTALL MS20600AD6W4 (OR CR9163-6-4) RIVETS ON SIDES (2 PLACES)
6. INSTALL MS20600AD6W8 (OR CR9163-6-8) RIVETS ON TOP (1 PLACE)
7. SEAL EDGE OF D2706 STEP WITH SIKAFLEX-241 (OR EQUIVALENT)  
SEALANT PER MANUFACTURER'S SPECIFICATION